

Work Order ID 82698

Thursday, April 05, 2012 7:57:05 AM

82698

Page 1

Item ID: D3321-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate,RH Fwd LH Mid
 Start Date: 4/5/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 4/20/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: *12-04-5* Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3321	Rev B								

100 PURCHASING 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg
 1010 16GA Dwg Rev: *B*
 Prog Rev: *B*
 2-Deburr if necessary
Jm. B12-4-9
 (6)

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00
 Quality Control
S. Zlotka
 (46)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* Brake NC Brake NC	NC BRAKE Memo 1- Form using DT8179 Die as per Dwg D3321 Rev: <u>B</u>	0.00 0.00				<u>6</u>	<u>6</u>		<u>JB 12/04/10</u>
150 *150* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00		<u>6 12/04/10</u>		<u>40</u>			
160 *160* Large Fab Large Fab	Weld per dwg A/R Hardcoat steel Batch: <u>M/19712-228</u> Large Fab Memo Weld hard surface using D3321-1T3 as per QSI 604 and Dwg D3321	0.00 0.00				<u>46</u>		<u>ME/MAL 12-04-17</u>	

W/O:		WORK ORDER CHANGES					
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 Start Date: 4/5/2012 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 4/20/2012 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo QCS →	0.00 0.00				(x6)			
180 *180* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: 10:20 OVEN TEMPERATURE: 3200F FINISH TIME: 10:50	0.00 0.00				6X			M-L 12/34/20
190 *190* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				6			12/4-28.

M117338

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

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Thursday, April 05, 2012 7:57:05 AM

Item ID: D3321-2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate,RH Fwd LH Mid

Start Date: 4/5/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 4/20/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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200

Identify as per dwg & Stock Location: 498

0.00

200

Packaging

Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

12/4/23
1204-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Thursday, April 05, 2012 7:57:11 AM

Work Order ID: 82698

82698

Parent Item: D3321-2

D3321-2

Parent Item Name: Wearplate,RH Fwd LH Mid

Start Date: 4/5/2012

Required Date: 4/20/2012

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP: A05.05.12New issueKJ/JLM

IPP REV:B

12.04.03 NOW MADE IN HOUSE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M1010S16GA

Purchased

No

100

sf

163.4200

1.56

9.852632

M1010S16GA

1010/1025 sheet 16GA

** JM 1312-4-9 ⑥

Location

Loc Qty

Loc Code

MAT019

163.42

116791

21.4

117500

16.02

118965

30

121195

96

116791 X1

121195 X5

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 82698
Description: WEARPLATE R14 EWD LH MID		Part Number: D3321-2
Inspection Dwg: D3321	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

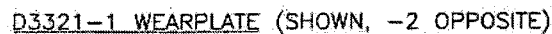
☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
266	$\pm .010$	268	✓		Vern	HB-02
438	$\pm .010$	438	✓		Vern	HB-02
318	$\pm .010$	318	✓		Vern	HB-02
3.130	$\pm .010$	3.133	✓		Vern	HB-02
3.938	$\pm .010$	3.939	✓		Vern	HB-02
2.396	$\pm .010$	2.398	✓		Vern	HB-02
ϕ 1.80	$+1.008 - .001$	1.83	✓		Vern	HB-02
.38	$\pm .010$.378	✓		Vern	HB-02
6.012	$\pm .010$	6.016	✓		Vern	HB-02
10.958	$\pm .010$	10.966	✓		Vern	HB-02 PROD-W-J-02
13.898	$\pm .010$	13.898	✓		MT	HB-01
15.950	$\pm .010$	15.950	✓		MT	HB-01
19.981	$\pm .010$	19.981	✓		MT	HB-01
24.042	$\pm .010$	24.042	✓		MT	HB-01
32.137	$\pm .010$	32.137	✓		MT	HB-01
40.199	$\pm .010$	40.199	✓		MT	HB-01
48.262	$\pm .010$	48.262	✓		MT	HB-01
56.357	$\pm .010$	56.357	✓		MT	HB-01
57.05	$\pm .030$	57.05	✓		MT	HB-01
.060	$\pm .010$	0.058	✓		Vern	HB-02

Measured by: B / Jm	Audited by: J	Prototype Approval:
Date: 12-4-9	Date: 12/04/09	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Copyright © 2005 by DART AEROSPACE LTD



- 1) MATERIAL: A/SI 1010-1025 OR ASTM A36/A366/A1008 OR
CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSION ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3321-X B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

RELEASED
05.11.30
3

DART

DESIGN A1		DRAWING BY AH		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3321		REV. B	
DATE 05.04.29		TITLE WEARPLATE		SHEET 1 OF 2	
A	04.10.01	NEW ISSUE		SCALE 1:15	
B	05.04.29	ADJUST GEOMETRY			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

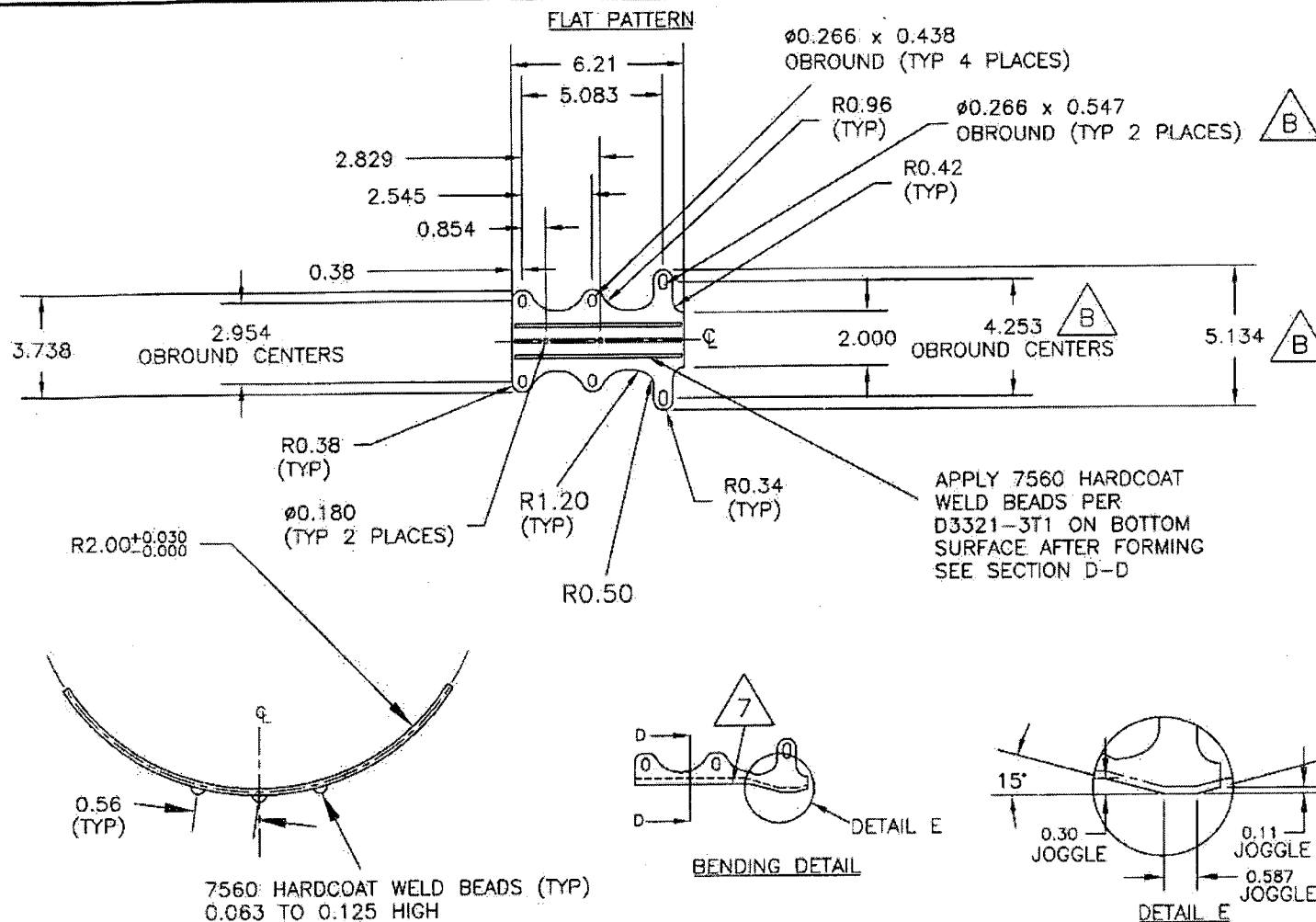
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

82698



D3321-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRICAL ABOUT CENTERLINE
- 6) ALL DIMENSION ARE IN INCHES
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3321-3 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-17"

RELEASED
05/11/30

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD HAMMERSBURG, ONTARIO, CANADA
CHECKED	PH	APPROVED	PH	DRAWING NO. D3321
DATE	05.04.29	TITLE	WEARPLATE	REV. B
SCALE	1:6			SHEET 2 OF 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries